

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016263**Date Inspected:** 15-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Yang Bai Qian.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

Subassembly, Bay 04, 13BW, Deck panel to U-rib.

FCAW Repair welding of partial penetration weld joints DP3130-001-002, 003, 005, 006, 116; located on subassembly, Bay 04, 13BW. Welder is identified as 062265; ZPMC Quality Control Inspector (QC) is identified as Yang Bai Qian. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-FCAW-2G(2F)-FCM-REPAIR.

Y-Locations for the repairs were;

W002 – 4750mm.

W003 – 4750mm.

W005 – 550mm.

W006 – 4750mm.

W116 – 50mm.

Subassembly, Bay 04, 13BE, Deck panel to U-rib.

During Random Visual in process Inspection, this QA inspector observed ZPMC personnel carrying out Weld repairs after visual testing on Deck panel to U-rib welds of Deck Panel DP3087-001. Repair carried out with Flux core arc welding (FCAW). Welder is identified as 203805; ZPMC Quality Control Inspector (QC) is identified as Yang Bai Qian. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the

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Applicable WPS: WPS-345-FCAW-2G(2F)-FCM-REPAIR.

Welds & Approximate Y-locations of repair were;

W001 – 1250mm.

W002 – 2450, 3050mm.

W003 – 3050mm.

Subassembly, Bay 04, Floor beam Stiffener (Relocation).

FCAW Critical Repair welding of Complete Penetration (CJP) weld joint FB3124-001-35, 38 (CWR#B-CWR1713); located on assembly, Bay 04. Welder is identified as 206586; ZPMC Quality Control Inspector (QC) is identified as Chen Xi. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2232-TC-U4B-F.

This QA Inspector carried out NDE on following

Subassembly, Bay 02, Traveler rail welds.

This QA inspector performs Random Visual Testing (VT) & random Magnetic Particle Testing (MT) of approximately 15% area previously tested and accepted by ZPMC Quality Control personnel (Notification # 06404). This QA Inspector generated an MT report (TL-6028) for this date. The members are identified as

- 1) 10TR1-026-003to 014.
- 2) 10TR1-003-003to 014.
- 3) 11TR1-029-003to 014.
- 4) 10TR2-022-003to 014.
- 5) 11TR1-013-003to 014.
- 6) 11TR2-004-003to 014.
- 7) 10TR2-014-003to 014.
- 8) 11TR1-019-003to 014.
- 9) 10TR2-013-003to 014.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 1500.042.2372, who represents the Office of Structural Materials for your project.

Inspected By:	Juvekar,Amit	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
